



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2594-1

Job Sheet 181627



Part No: D2594-1

Job Qty: 100 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/2/18

Job Tracking No:

Due Date: 8/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP E 06.12.11 ecn 836 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	8/10/18	8/10/18	0.00	0.00	Start Up Machining		14/8/13 JAD
100	Hardinge	100 pcs	8/10/18	8/10/18	0.01	2.87	Hardinge		14/8/13 JAD
110	QC	100 pcs	8/10/18	8/10/18	0.00	0.00	QC2		JBD
120	QC	100 pcs	8/10/18	8/10/18	0.00	0.00	QC8		B. 18-08-13
130	HandFinish	100 pcs	8/10/18	8/10/18	0.00	0.23	HandFinish1		DR 18-08-14
135	Powdercoat	100 pcs	8/10/18	8/10/18	0.00	0.15	Powdercoat1		14/8/13 JAD
150	QC	100 pcs	8/10/18	8/10/18	0.00	0.00	QC3		14/8/13 JAD
160	Packaging	100 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3	FP001	3EB 18-08-15
170	QC21-SA	100 Ea	8/10/18	8/10/18	0.00	0.00	QC21		14/8/13 JAD

Part Op 100 - 1-Make as per Dwg D2594-1 and Folio FA262.

Descriptions: 135 - START TIME:

160 - LOCATION : FP001

DAS
21
9-69
AUG 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	5.2100 ft (.0521 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.625	5	135	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches $\pm$ 0.005	0.065 0.055		
2	Plug	0.500inches $\pm$ 0.010	0.510 0.490		
3	Plug	0.625inches $\pm$ 0.010	0.635 0.615		
4	Plug	0.430inches + 0.000 - 0.002	0.430 0.428		
5	Plug	0.090inches	0.090		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

			+ 0.000	0.088
			- 0.002	
6	Plug		+ 0.000	0.045
		0.045inches	- 0.002	0.043

Plex 8/2/18 8:56 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Dart Aerospace Ltd. 1270 Aberdeen Street Newkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-6200 Email: sales@dartero.com www.dartaerospace.com Date: 08/13/18 Container No: S101471 Part: D2594-1 Job No: 181627 Serial No/Batch: S101471 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's																																																																																																												
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